

Work Order ID 132622

Thursday, May 07, 2015 2:59:16 PM

132622

Page 1

Item ID: D350-636-045

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Standard Wearplates & Wearpads AS350 / AS355 (CHG004 or sub) Fits LH or RH

Stop

NS2

Start Date: 5/2/2015 Start Qty: 1.00

1 3

Cust Item ID:

Required Date: 5/7/2015 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAY 11 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D350-636	J

100 Document Control 0.00

100

DC APR 26 2015

Doc.Control -USB or Paperwork

Memo 7/10 0.00

Photocopy bluefile & type labels per PPP D350-636-045 CHG001

DAS 6 9-89 3x 28 27 MAY 25 2015

110 Pick Kit 0.00

110

Packaging Memo 0.00

Packaging

3x DAS 28 27 9-89 MAY 25 2015

120 QC4- 100% Inspect kits for completeness 0.00

120

QC Memo 0.00

Quality Control

APR 26 2015

3x DAS 6 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
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OTHER :																									

Work Order ID 132622

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132622

Page 2

Item ID: D350-636-045

Accept

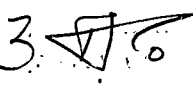
N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Standard Wearplates & Wearpads AS350 / AS355 (CHG004 or sub) Fits LH or RH

Start Date: 5/2/2015 Start Qty: 1.00

1 3 

Cust Item ID:

Required Date: 5/7/2015 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging					34			
Packaging	Memo	0.00							DAS 6 9-89
Packaging	Identify and pack for shipping as per PPP D350-636-045 Location: <u>125A</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MAY 27 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

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132622

Parent Item: D350-636-045

D350-636-045

Parent Item Name: Standard Wearplates & Wearpads AS350 / AS355 (CHG004 or sub) Fits LH or RH

Start Date: 5/2/2015

Required Date: 5/7/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-05-22 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3537-1		Manufactured	No			110	Each	117.0000					
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D3537-1
Wearpad

★★

DAS MAY 25 2015

28
9-89
27
9-89

Location	Loc Qty	Loc Code
FG	18	
79833	8	
88562	10	
FP001	67	
126306	1	
128225	3	
128762	2	
130493	48	
131358	13	
ST611	32	
125911	29	
90197	3	

DAS
6
9-89

D3535-25

Manufactured No

110 Each 26.0000

D3535-25
Wearplate Center

★★

DAS
28
9-89
27
9-89

Location	Loc Qty	Loc Code
FG	2	
95077	2	
FP002	24	
125908	1	
128224	23	

DAS
6
9-89

3

DQA: _____ Date: _____



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Parent Item Name: Standard Wearplates & Wearpads AS350 / AS355 (CHG004 or sub) Fits LH or RH

Start Date: 5/2/2015

Required Date: 5/7/2015

D3536-25

Manufactured No

110

Each

15.0000

Start Qty: 1.00

Required Qty: 1.00

D3536-25
Gasket Center

DAS
6
9-89 /

Location	Loc Qty	Loc Code
FG	6	
87053	2	
95328	4	
FP001	9	
125909	1	
130823	7	
89057	1	

132316

DAS
28
9-89 27
9-89

MAY 25 2015

D3791-1

Manufactured No

110

Each

3.0000

D3791-1
Wearpad

DAS
6
9-89 /

Location	Loc Qty	Loc Code
FP002	3	
126317	3	

128234 x 1

DAS
28
9-89 27
9-89

D3793-1

Manufactured No

110

Each

21.0000

D3793-1
Wearplate Fwd

DAS
6
9-89 /

Location	Loc Qty	Loc Code
FP002	21	
130508	21	

2
13

DAS
28
9-89 27
9-89

D3793-3

Manufactured No

110

Each

20.0000

D3793-3
Wearplate Aft

DAS
6
9-89 /

Location	Loc Qty	Loc Code
FP002	20	
130534	20	

3
13

DAS
28
9-89 27
9-89

3

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Shop Packet Print

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
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Root Cause		FAULT CATEGORY			
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Parent Item: D350-636-045

D350-636-045

Parent Item Name: Standard Wearplates & Wearpads AS350 / AS355 (CHG004 or sub) Fits LH or RH

Start Date: 5/2/2015

Required Date: 5/7/2015

D3794-1

Manufactured No

110

Each

25.0000

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Gasket Fwd

**

DAS 28 27 9-89 MAY 25 2015

DAS 6 9-89

Location

Loc Qty

Loc Code

FP001

25

128238

1

130509

24

D3794-3

Manufactured No

110

Each

38.0000

**

DAS

D3794-3

Gasket Aft

DAS 6 9-89

Location

Loc Qty

Loc Code

FP001

38

125917

1

127383

35

128239

1

92658

1

AN3C5A

Purchased

No

110

Each

676.0000

**

DAS 28 27 9-89

AN3C5A

Bolt

DAS 6 9-89

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

6

M131420

6

ST

56

121708

56

ST338a

600

M130851

16

M131803

584

ST350

9

M131320

9

Thursday, May 07, 2015 2:59:19 PM

Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																								
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Misidentified ☐	Past Due ☐	OTHER : _____																																																																										

Picklist Print

Thursday, May 07, 2015 2:59:19 PM

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Work Order ID: 132622

132622

Parent Item: D350-636-045

D350-636-045

Parent Item Name: Standard Wearplates & Wearpads AS350 / AS355 (CHG004 or sub) Fits LH or RH

Start Date: 5/2/2015

Required Date: 5/7/2015

NAS1149C0332R

Purchased

No

110

Each

2,869.000

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

WASHER

**

DAS

28

9-89

DAS

28

9-89

27 MAY 25 2015

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

642

m131618

642

ST260a

87

m131697

87

DAS
6
9-89

132262

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Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No.: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

6.0 PARTS LIST (D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 004 OR LATER)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAISER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-045	WEARSHOE KIT
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2		AN960JD816	WASHER (OR NAS1149DO863J)
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER
*20B	4	4	4	4		NAS1515H3L	WASHER

(CONTINUED ON NEXT PAGE)

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
*22	3	3	3	3	3	D3537-1	WEARPAD
*22A	1	1	1	1	1	D3791-1	WEARPLATE (REPLACES D3537-1)
*23A	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*23B	1	1	1	1	1	D3794-1	GASKET (REPLACES D3536-13)
*24A	1	1	1	1	1	D3535-25	WEARSHOE
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*25B	1	1	1	1	1	D3794-3	GASKET (REPLACES D3536-35)
*26A	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	AN980C10L	WASHER
*28	34	34	34	34		ALS4-1032-225	INSERT
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	2	2		D3493-1	WASHER
50	2	2				D3532-1	SPACER

* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

Thursday, May 07, 2015 2:59:16 PM

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

1 3 ~~110~~

Cust Item ID:

Required Date: 5/7/2015 Req'd Qty: 1.00

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MCS Date: MAY 11 2015 Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D350-636	J

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo *7, 10*

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-636-045 CHG001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

MCS 15-05-25
~~3x~~ DAS 28 MAY 25 2015 9:00
 3

3x DAS MAY 25 2015
28
9-89